Qty:

Date: User Tuesday, 8/7/2007 9:14:55 AM

Jean-Luc Menard

Process Sheet

:Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 33832

Estimate Number

: 11180

P.O. Number This Issue

Prsht Rev.

First Issue

Previous Run

: JA 8/7/2007

: 33390B

S.O. No. : 1/1A

LARGE FAB ASSY

Part Number **Drawing Number**

Drawing Name

: D2282043 D2282 REV E

Project Number **Drawing Revision**

: N/A : NA

Material **Due Date** : 8/14/2007

: SADDLE ASSEMBLY

50 Um:

Each

Written By

Checked & Approved By

Comment

: Est Rev:A

Removed from 9 Digit

05-12-02 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D2281



Jack Saddle



Comment: Qty.:

1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Tube

Total: 100.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2281

Saddle **B33414**

Ab7/08/07

2.0

D22827



2.0000 Each(s)/Unit



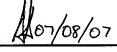
Comment: Qty.:

Pick:

Qty Part Number 2 D2282-7

Description Batch

tube B 33417





3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1





Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-043 Saddle Assembly Grind chamfers and ensure full penetration.

A/R

ER316L SS

Filling Rod <u>M /02421</u> / M*l* 05138 Dwg Rev: <u>E</u>

4.0

DO NOT USE

WELD INSPECTION



Comment: WELD INSPECTION



Form: rprocess

Date: Tuesday, 8/7/2007 9:14:55 AM User: Jean-Luc Menard **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: SADDLE ASSEMBLY Job Number: 33832 Part Number: D2282043 Job Number: Seq. #: **Machine Or Operation:** Description: 5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble 6.0 QC5 INSPECT WORK TO CURRENT STEE Comment: INSPECT WORK TO CURRENT STEP 7.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: GA 8.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE £67/08/10 Job Completion